

**Work Order ID 68047**

Tuesday, April 05, 2011 3:14:03 PM



Page 1

Item ID: D4278-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4278

C

100

Weld per dwg A/R S.S. rod Batch: 115328

0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg DT

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-04-07

2

0

BE 11/04/07

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Submittal

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68047**

Tuesday, April 05, 2011 3:14:03 PM



Page 2

Item ID: D4278-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: *B/C*

0.00

Memo

0.00

\*\*\*STOCK IN BASKET CELL\*\*\*

*PL 11-04-08*

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*11/4/13**11-04-13  
(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 05, 2011 3:14:09 PM

Page 1

Work Order ID: 68047



Parent Item: D4278-045



Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 4/5/2011



Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC  
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-11  Rib		Manufactured	No			100	Each	0.0000	1	2			
D4277-7  Rib		Manufactured	No			100	Each	0.0000	1	2			



B68048 → (2) Pl 11.04.06



B68055 → (2) Pl 11.04.06

**Dart Aerospace Ltd**

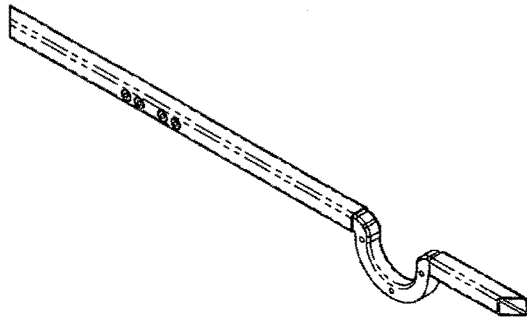
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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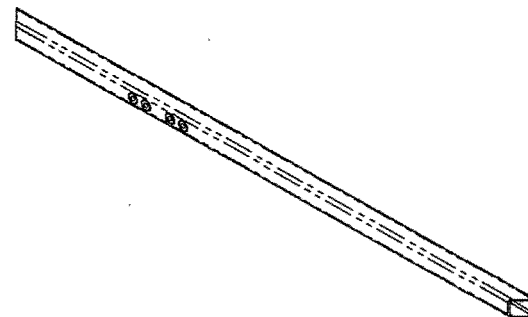
**NOTE:** Date & initial all entries



**D4278-041 UPPER RIB ASSY-HOOP**



**D4278-045 RIB ASSY, FWD CHAM**



**D4278-047 UPPER RIB ASSY-STRAIGHT**



**RELEASED**  
2011-01-18  
MM

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68047  
*PL 11-04-5*

REV.	DESCRIPTION	BY	DATE
C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4278</b>	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
DATE	10.12.23	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

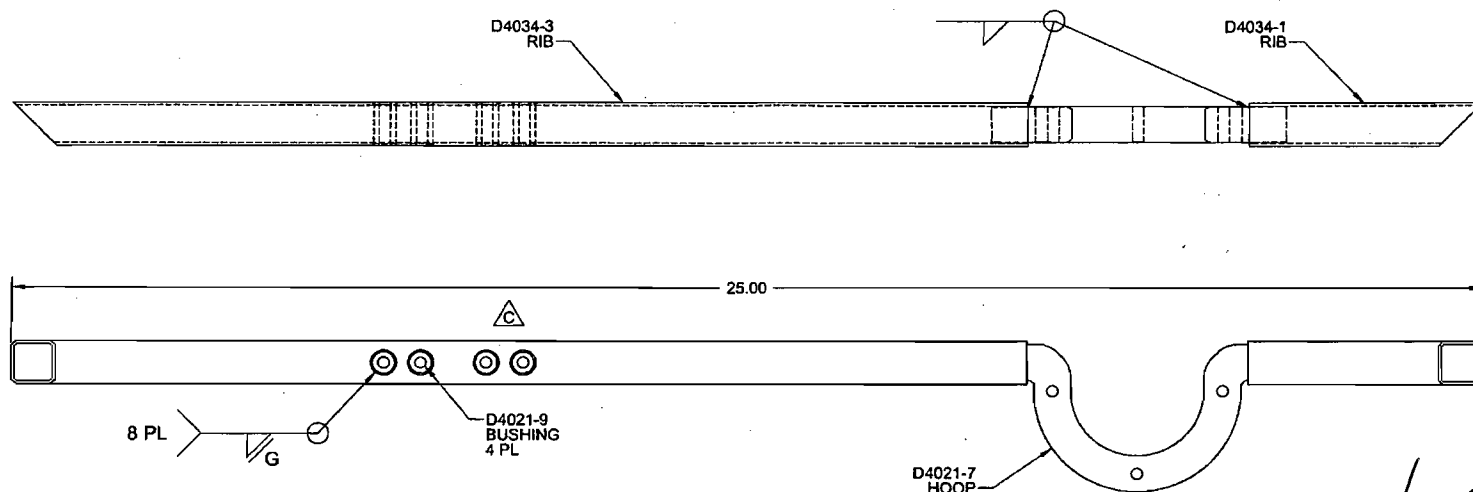
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



**D4278-041 UPPER RIB ASSY-HOOP**

*u/o 68047*

**RELEASED**  
2011-01-18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	<b>DART AEROSPACE LTD</b>	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

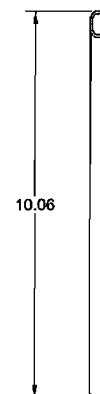
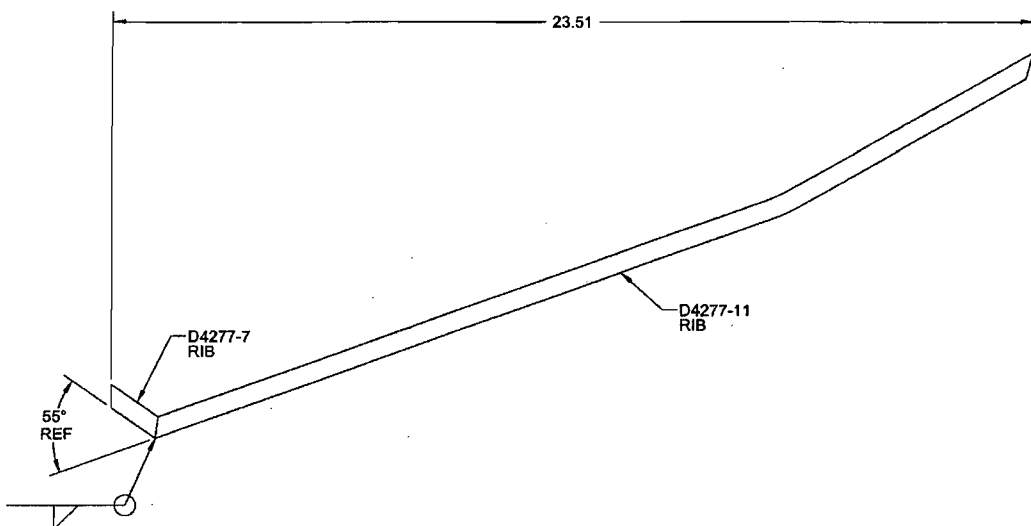
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	<input checked="" type="checkbox"/>	D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



*u/068097*

**D4278-045 RIB ASSY, FWD CHAM**

**RELEASED**  
2011-01-18

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JRH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4278</b>	REV. C
MFG APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
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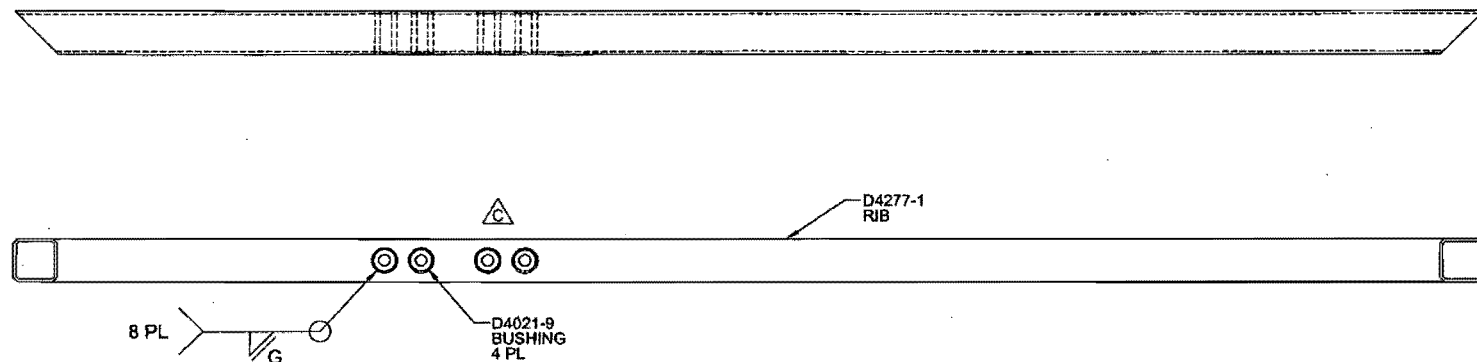
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	<del>1</del>	D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



**D4278-047 UPPER RIB ASSY-STRAIGHT**

W/ 68047

RELEASED  
2011-01-10  
JMP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
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CHECKED	A	DRAWING NO.	REV. C
MFG. APPR.	A	D4278	SHEET 4 OF 4
APPROVED	JMP	TITLE	SCALE
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